

Cylindrical broach Ø40 Z78

A14-020

The resharpening process of this example tool contains the regrinding of the flute and O.D. The teeth can be ground in several sub groups and therefore with different geometry parameters. The division can be reproduced either according a fix definition in Quinto or the probed division on the tool.



1. Cycletime for Resharpening

Workpiece:	Diameter 40mm; Nbr of teeth 78 Material HSS		
Operations	Probe	Flute 1	O.D.1
Feed [mm/Min]	5000	12000	1000
Power [kW]		3	2
Cutting feed [m/s]		30	33
Used wheels		1	2
Grinding time [s]	6	8702	1141
Total cycle time	164 Min 8		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14F1 Ø50 B91
2	1V1 Ø125 B91



1

2

3. Machine and Software Requirements

Machines: 6 axes CNC grinders : Corvus BBA Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories: Dog and driver, Hydraulic tailstock, Support

Responsible engineer: SIS. 12.2.10

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland
Subsidiaries in: France, Deutschland, Italia, United States, China

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